

DART AEROSPACE LTD		Work Order:	22489
Description: Cabin Heater (206)		Part Number:	DSI 9051
Dwg: D2003 Rev. B; D2008 Rev. -; DSI 9051		Qty:	1 Kit(s)
Ref:		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler (1) DSI 9051 consists of (2) D2003-077; (4) D2008-001	HA	05.03.02	1
2	DC	Photocopy bluefile and create labels as per PPP DSI 9051 CHG001	HA	05.03.02	1
3	MV	Cut (4) D2008-001 blanks per (1) DSI 9051 Kit Cut blanks: 2.100" x 2.100" x 0.028" thick Material: Kydex 100 () Identify for D2008-001 Batch: M16909	HA	05.03.02	4
4	MV	Machine as per Folio and Dwg D2008-001 Stack of 4 fabricate by hand Identify as D2008-001	HA	05.03.02	4
5	QC2	Inspect parts as they come off the CNC machine	N/A	u	
6	QC85	Second check	N/A	u	
7	MV	Deburr	N/A	u	
8	GA	Cut (2) D2003-077 blanks per (1) DSI 9051 Kit Cut blanks: 6.250" long as per template D2003-077 Material: 6061-T6 tubing 0.375OD x 0.035" wall (M6061T6T0.375W.035) Identify for D2003-077 Batch: M15773	HA	05.03.02	2
9	GA	Form, drill & flare as per template D2003-077	HA	05.03.02	2
10	GA	Assemble as per Dwg D2003 Pick: Packing Kit Qty Part Number Description Batch 2 5/16"-200 Set Screw M16909 2 AN818-6D Nut M16322 2 MS20819-6D Sleeve M16322 Identify as D2003-077	HA	05.03.02	2
11	QC5	Inspect work to Step 10	2	05.03.08	2
12	ST	Pick: Packing Kit (Note: D2003-077 & D2008-001 are on BOM as material from Steps 3 & 8) Qty Part Number Description Batch 2 D2003-077 Jet B22484 4 D2008-001 Doubler B22484 2 AN833-6D Elbow M16323 2 AN924-6D Nut M16323	HA	05.03.08	1
13	QC4	Inspect Kit 100% for Completeness on the W/O	HA	05.03.08	1
14	PK	Identify and pack for shipping as per PPP DSI 9051	HA	05.03.08	1
15	AC	Cost / part	HA	05.03.08	1
16	DC	Close W/O Inspect Level 21	HA	05.03.08	1

PRELIMINARY ISSUE

Rev	Date	Change	Revised By	Approved
A	04.05.17	New issue	KJ/JLM	HA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

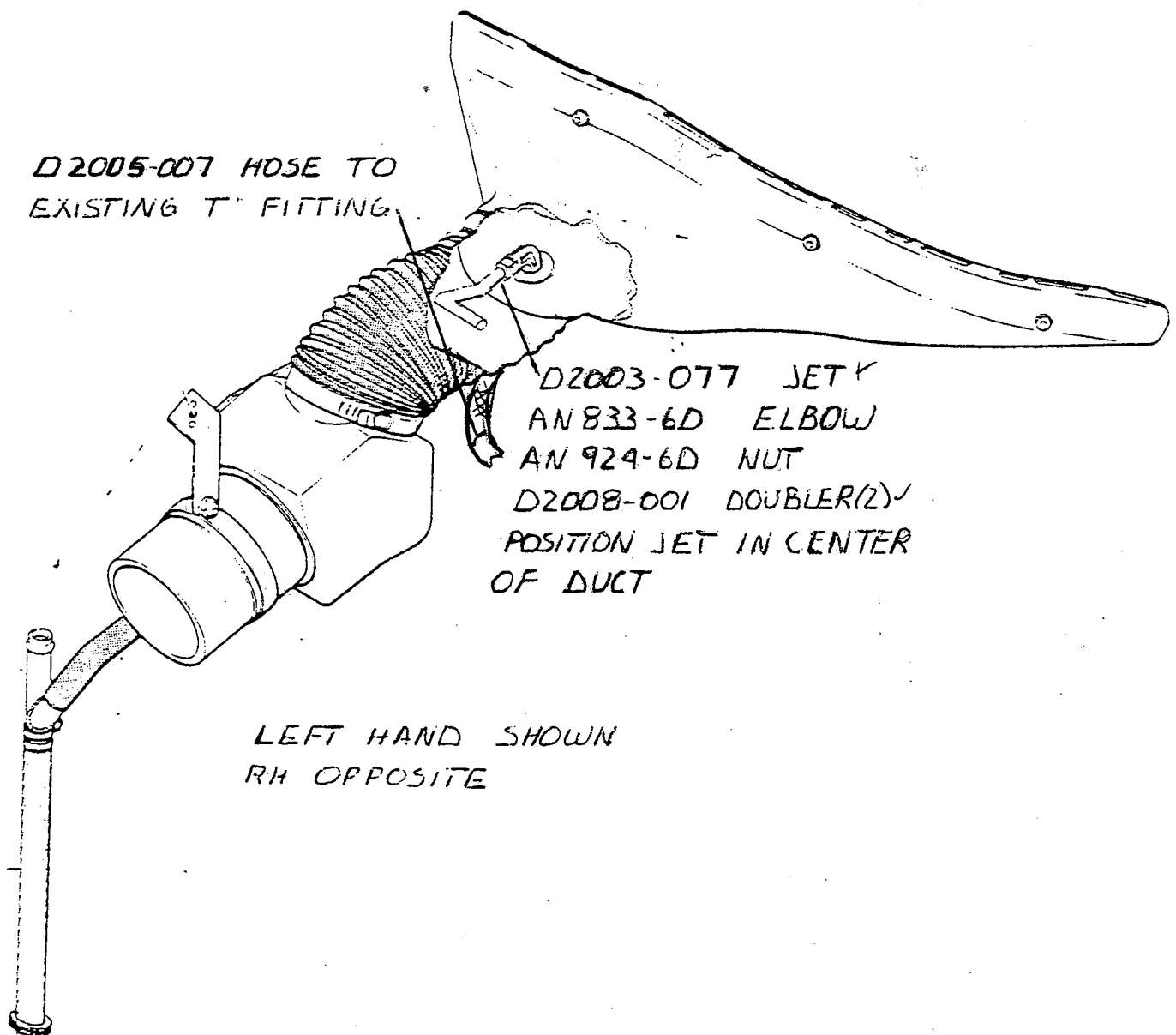
QA: N/C Closed: _____ Date: _____

DESIGN <i>BU</i>	DRAWN BY <i>BU</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>Pon</i>	DRAWING NO. DSI 9051	REV. A SHEET 1 OF 1
DATE 96:10:30		TITLE ADDITION OF ASPIRATORS	

DART SERVICE INSTRUCTION DSI 9051
AMMEND DRAWING D206-570
ADD ASPIRATOR JETS AS OPTION TO INSTALLATION

703-013
-015

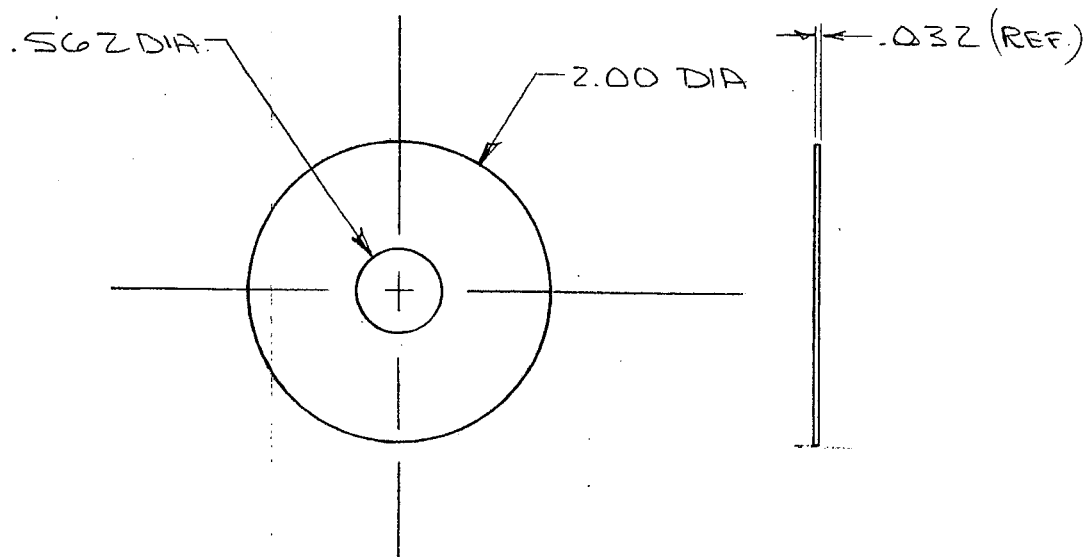
D2005-007 HOSE TO
EXISTING T FITTING



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D 2008



DETAIL OF - 001

D 2008-001		DOUBLER	.032 THK	KYDEX 100
PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DART AERO ACCESSORIES INC				
CONTRACT NO.	DATE	TITLE		
DRAWN Bessley	90.12.01	DOUBLER		
DESIGN Bessley	90.12.01	D 2008		
CHECKED		CODE	DWG. NO.	REV.
CLIENT			SCALE 1:1	SHT 1 OF 1

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523
DRAWN			BASIC CODE
APPROVED			D-DIMPLE D-DIMPLE OF SHEETS C-COUNTERSINK
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES. 2. SURFACE ROUGHNESS 125. 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER MIL. S-1742 5. HOLS. PER AND 10387 1. TOLERANCES — .XX ± .030 2. ANGLES 1/2° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX. 5. SYMMETRY ABOUT ALL MAT. CENTRE LINES .005		DASH NO WH-HEAD NEAR SIDE WH-HEAD FAR SIDE LENGTH DASH NO WH-SPOTWELD BASIC CODES B-MMS20410AD B-MMS20420AD
REPORT ALL DISCREPANCIES — DO NOT SCALE			



RELEASED
49.06.09 KE

DESIGN <i>A</i>	DRAWN BY <i>SP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>A</i>	DRAWING NO. D2003	REV. B SHEET 1 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	
A	90.04.09	NEW ISSUE	
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

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P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/5/7}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6



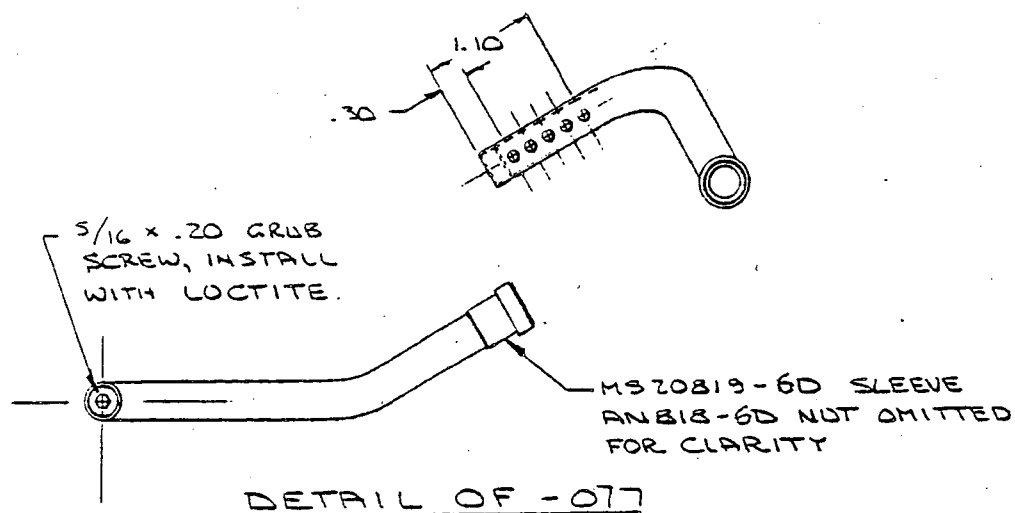
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2003	REV. 8 SHEET 2 OF 2
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES	SCALE NTS

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99.06.09 KE

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Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
10:21 am

Work Order No : 0022484
Project Name : DSI9051
Project For : WK509
Work Order Type : Main
Main WO Number :
House Part Number : *DSI 9051
Description : Aspirator Jet addition
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 02-18-05
Est Finish Date : 02-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
*Profits/(Loss) :	0.00	0.00